

Date: Wednesday, 30/01/2008 2:24:02 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 37120 -1
 Estimate Number : 13108
 P.O. Number :
 This Issue : 30/01/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 07-12-19 new issue ECN960 DD

Drawing Name : CYCLIC STICK

Part Number : D3630041
 Drawing Number : D3630 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 06/02/2008

Qty: 35 Um: Each

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M304TR1125W065 304 RD Tube 1.125 x .065w

Comment: Qty.: 2.4497 f(s)/Unit Total : 12.2483 f(s)

Material: 304/316 SS Seamless Tubing 1.125" OD x 0.065" wall(M304TR1125W065)

Batch: M107149 M108225

FF 08-03-13 (7)

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D3630

2-Debur

3-form D3630-5 as per dwg D3630

FF 08-03-13 (7)

3.0 QC5 INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

S 08/06/10 (7)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1- Weld as per dwg D3630 and QSI004

2- Grind weld flush

08-06-12 1

5.0 QC9 VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION

08-06-12 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3630-041 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 9/10/14
 QA: N/C Closed: _____ Date: _____

NCR: <u>37120-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/19	2	8 pieces were scrap didn't have good radius, 3 pieces were try out	<i>[Signature]</i> 08/03/19	Scrap & destroy	FF 08/03/19	<i>[Signature]</i> 08/03/19	<i>[Signature]</i> 08/03/19	<i>[Signature]</i> 08/03/19
08/06/09	2	3PCS were damaged, Tool on bend was changed incorrectly installed we Fixed it	<i>[Signature]</i> 08/06/09	Scrap and replaced	FF 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09
08/06/09	2	1 over bend human error	<i>[Signature]</i> 08/06/09	Scrap and destroyed Not replaced.	FF 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09

NOTE: Date & initial all entries

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Drawing Name: CYCLIC STICK

Job Number: 37120

Part Number: D3630041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/06/12 (80)

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-Drill holes as per dwg D3630
2- deburr

SB 08/06/13 (1)

MF 08/06/12 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/06/13 (80)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- remove all scratches

SB 08/06/13 (1)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/06/13 (80)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: 108/6/13 (1)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

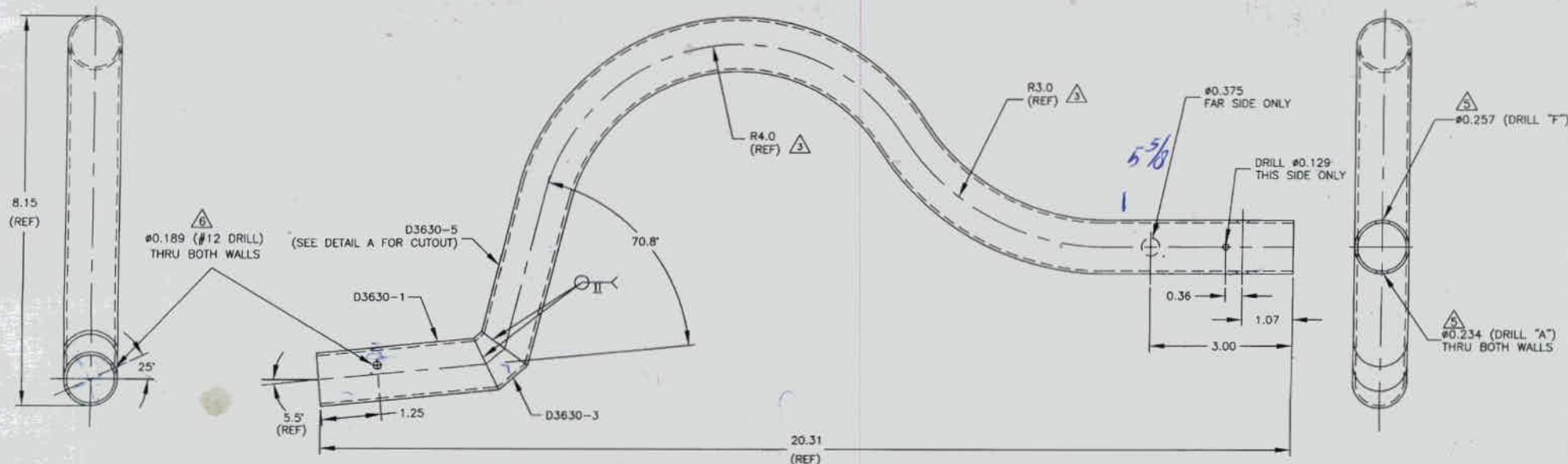
08/06/13 (1)

Job Completion



MF 08-06-13

Start at $5\frac{5}{8}$ until ~~60~~ 62° "click"
change to bigger radius go to 130° click



D3630-041 CYCLIC STICK (REPLACES GENEVA P/N G10202)

RELEASED
07-11-11

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS
ROUND TUBING 1.125" OD X 0.065" WALL
(REF. DART SPEC M304TR1.125W.065)
- 2) FINISH: NONE
- 3) REFER TO TEMPLATE DT8940
- 4) WELD PER DART QSI 004
- 5) DRILL #0.234 THRU BOTH WALLS
THEN DRILL #0.257 THRU ONE WALL AS SHOWN
- 6) DRILL #0.189 THRU BOTH WALLS
AT 25° OFF HORIZONTAL AXIS AS SHOWN
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 9) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 10) IDENTIFY WITH DART P/N "D3630-041" USING FINE POINT
PERMANENT INK MARKER

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-041	X	D3630-041
1	D3630-1	TUBE
1	D3630-3	TUBE
1	D3630-5	TUBE

D3630-1
(REPLACES GENEVA P/N G10202-1)

D3630-3
(REPLACES GENEVA P/N G10202-2)



D3630-5
(REPLACES GENEVA P/N G10202-3)

DETAIL A: CUTOUT

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DART AEROSPACE USA, INC.

A	07.05.11	NEW ISSUE: REPLACES G10202
DESIGN CLB	DRAWN BY JC	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3630
DATE 07.05.11	TITLE CYCLIC STICK	REV. A SHEET 1 OF 1 SCALE 1:2

